




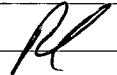




Work Order ID 62481

Thursday, September 30, 2010 2:21:51 PM


Page 1

Item ID:	D3201-4	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	9/30/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	10/8/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date: 10-9-30	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:		Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3201	Rev B


100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
2024 .056	1-Cut as per Dwg D3201 <input type="checkbox"/> Dwg Rev: B <input type="checkbox"/> Prog Rev: B <input type="checkbox"/> 2- Deburr if necessary								

HB 10-10-6

(12)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

HB 10-10-6

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

8/10/10/06

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62481

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Page 2

Item ID: D3201-4

Accept

Revision ID:

Item Name: Doubler

Start Date: 9/30/2010 Start Qty: 6.00

Required Date: 10/8/2010 Req'd Qty: 6.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr Stack								
140  Brake NC	NC BRAKE	0.00				12			
Brake NC	Memo	0.00							
	1-Bend as per Dwg D3201 dwg D3201								
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

☐ 2. Scribe part# and Batch# per

SP 10/10/14

SP 10/10/14

412
-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62481

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Item ID: D3201-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 9/30/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	<i>AK</i>	<i>10-10-15</i>		<i>(12)</i>			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>=7</i>	<i>10/10/15</i>		<i>12</i>	<i>0</i>		
180 Packaging Packaging	Identify as per dwg & Stock Location: <i>041</i> Memo	0.00 0.00				<i>01/14/18</i>		<i>(12)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62481

Thursday, September 30, 2010 2:21:51 PM

Page 4

Item ID: D3201-4

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 9/30/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/18
MF
10-10-18

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 62481



Parent Item: D3201-4



Parent Item Name: Doubler


Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A Removed from 9 Digit 06-01-25 JLM
IPP Rev:B Now on Waterjet 06-08-14 JLM
IPP Rev :C Added scribing, NCR262 07.11.29 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	109.8847	0.045	0.284211	1 1		

1310-10-6

Location

Loc Qty

Loc Code

MAT22

109.8847

111381

13.49

113189

0.3947

114968

96

111381

12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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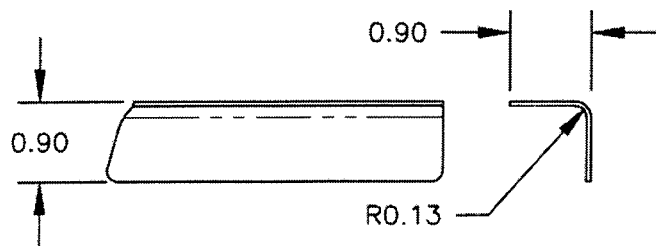
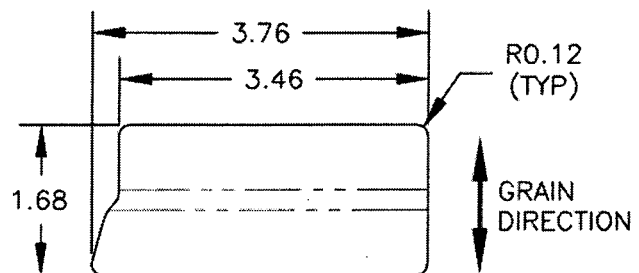
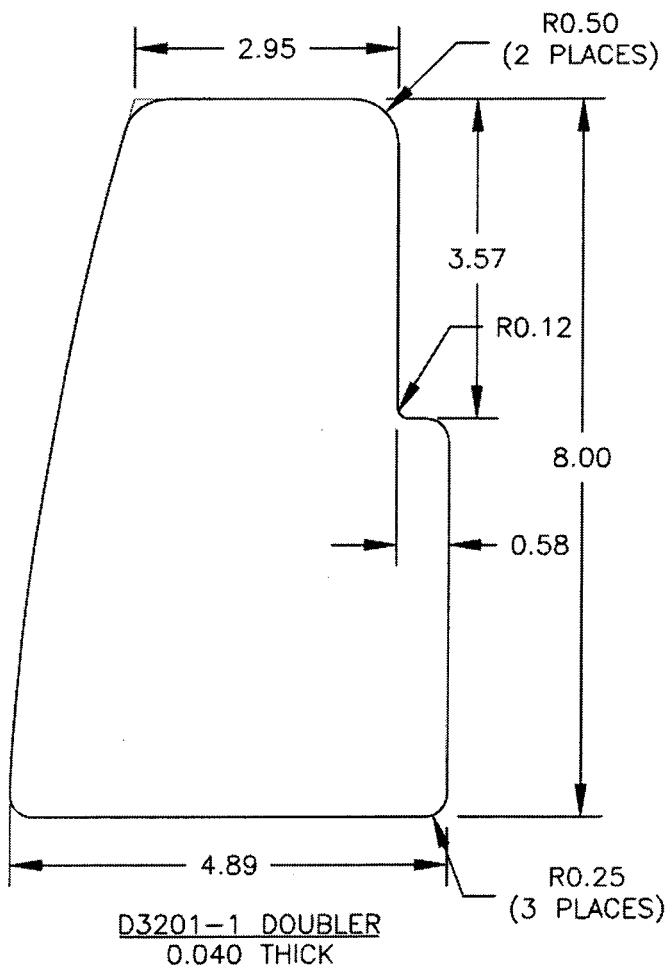
NOTE: Date & initial all entries



DESIGN <i>#</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03		TITLE DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.14

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. *62481* *DS10-930*



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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